Dart Aerospace Ltd.

Date: Tuesday, 12/5/2006 8:16:26 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number	: 29790		
Estimate Number	: 10834		
P.O. Number	: N/A	**Part Number**	: D29332
This Issue	: 12/5/2006 **S.O. No.** : N/A	**Drawing Number**	: D2933 UNDER REVIEW 06.12.05
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : MACHINED PARTS	**Drawing Revision**	: B
Previous Run	: 29233	**Material**	: N/A
Written By	:	**Due Date**	: 12/23/2006 **Qty:** 8 **Um:** Each
Checked & Approved By	: 06 12 05		
Comment	: Est: B 00006/26 New DWG rev (mpp 2069) EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25

Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Issue material from stock: 7075-T7351 QQ-A-250/12
Cut Size 2.0 x 6.25 X 6.00
Grain Along Long 6.00 Length
Batch No: B25345 mk 06/12/19 8

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
5-Deburr mk 06/12/20 8

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet mk 06/12/20 8

4.0	QC1	INSPECT ALL DIM TO DIM SHEET

Comment: INSPECT ALL DIM TO DIM SHEET mk 06/12/20 8

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
06.12.05	2	~~Tooling Ta~~ Tool rad for flange pockets should be R0.188 INSTEAD of R0.25-R0.30. -Ref attached DS email				GP 06.12.05 GP 1042	

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** D **Date:** 06/12/05

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:16:26 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 29790 **Part Number:** D29332

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	Cr 06/12/20 x (8)
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	M-R/a.m 06/12/21 (8)
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	M 10234/a.m 06/12/22 (8y)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT	06/12/22 (8)
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 5F475	06/12/22 (8) 6/12/22 (8)
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(8) 06/12/22

Job Completion CZ06/12/22

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29790
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.100	0.140		0.122	0.124	0.122	0.121		
B	0.100	0.140		0.120	0.124	0.121	0.121		
C	0.100	0.140		0.130	0.127	0.126	0.120		
D	0.210	0.230		0.219	0.221	0.220	0.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.499	2.500		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.572	1.582		1.576	1.577	1.577	1.576		
J	2.495	2.505		2.500	2.500	2.499	2.500		
K	0.257	0.262	~~DT8683~~	0.259	0.259	0.259	0.259		
L	0.312	0.317	~~DT8686~~	0.314	0.314	0.314	0.314		
M	0.235	0.240		0.236	0.237	0.236	0.236		
N	0.100	0.140		0.121	0.121	0.121	0.121		
O	0.540	0.560		0.547	0.550	0.550	0.551		
P	0.490	0.510		0.502	0.503	0.503	0.503		
Q	3.715	3.725		3.718	3.718	3.718	3.717		
R	2.470	2.510		2.495	2.503	2.495	2.500		
S	0.240	0.270		0.250	0.252	0.251	0.249		
T	0.100	0.180		0.140	0.142	0.143	0.143		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.365	1.367	1.366	1.366		
W	0.316	0.321	~~DT8690~~	0.320	0.320	0.320	0.319		
X	1.125	1.145		1.131	1.136	1.135	1.136		
Y	1.565	1.585	DT8695 A/B	1.567	1.567	1.569	1.572		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	
Date:	06/12/20

Audited by	
Date:	06/12/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	

DART AEROSPACE LTD	Work Order:	29790
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. B		Page 1 of 1

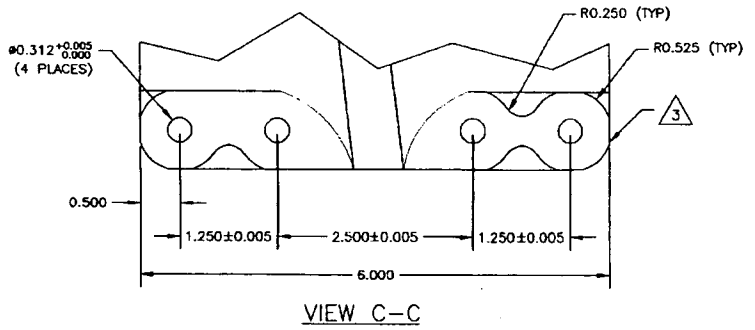
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.100	0.140		0.122	0.121	0.121	0.122		
B	0.100	0.140		0.121	0.121	0.121	0.121		
C	0.100	0.140		0.125	0.125	0.128	0.129		
D	0.210	0.230		0.221	0.221	0.221	0.221		
E	1.245	1.255		1.260	1.250	1.249	1.249		
F	1.245	1.255		1.250	1.250	1.249	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.572	1.582		1.576	1.576	1.577	1.578		
J	2.495	2.505		2.500	2.500	2.500	2.506		
K	0.257	0.262	~~DT8683~~	0.259	0.259	0.259	0.259		
L	0.312	0.317	~~DT8686~~	0.314	0.314	0.314	0.314		
M	0.235	0.240		0.236	0.236	0.236	0.236		
N	0.100	0.140		0.122	0.121	0.121	0.121		
O	0.540	0.560		0.552	0.550	0.551	0.551		
P	0.490	0.510		0.505	0.504	0.505	0.504		
Q	3.715	3.725		3.717	3.718	3.718	3.719		
R	2.470	2.510		2.499	2.499	2.497	2.497		
S	0.240	0.270		0.251	0.251	0.249	0.247		
T	0.100	0.180		0.145	0.143	0.146	0.145		
U	1.625	1.635		1.629	1.631	1.630	1.629		
V	1.362	1.372		1.366	1.366	1.367	1.366		
W	0.316	0.321	~~DT8690~~	0.320	0.320	0.320	0.320		
X	1.125	1.145		1.135	1.135	1.135	1.136		
Y	1.565	1.585	DT8695 A/B	1.571	1.573	1.574	1.575		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

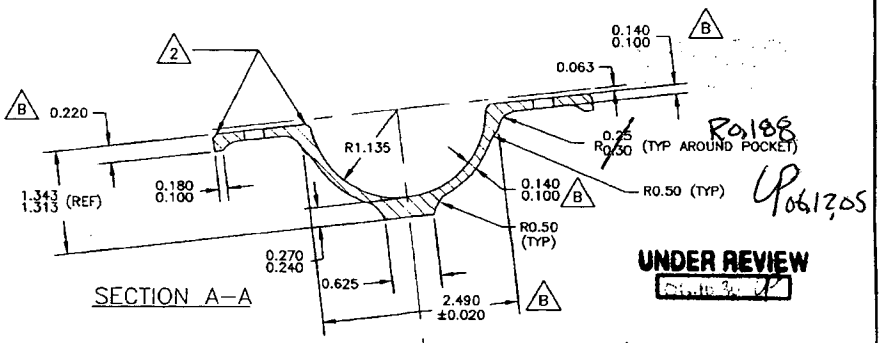
Measured by:	
Date:	06/12/20

Audited by	
Date:	06/12/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	



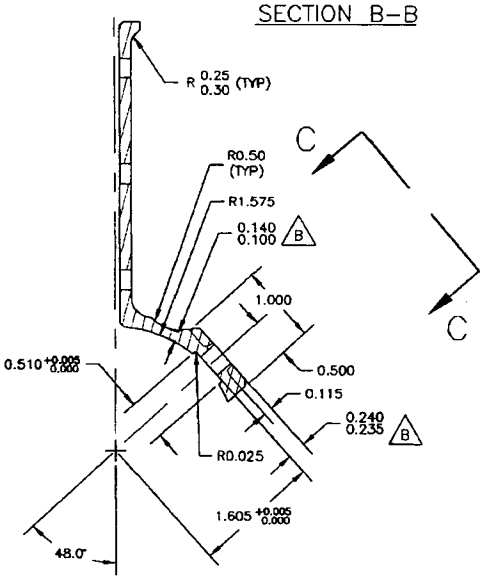
VIEW C–C

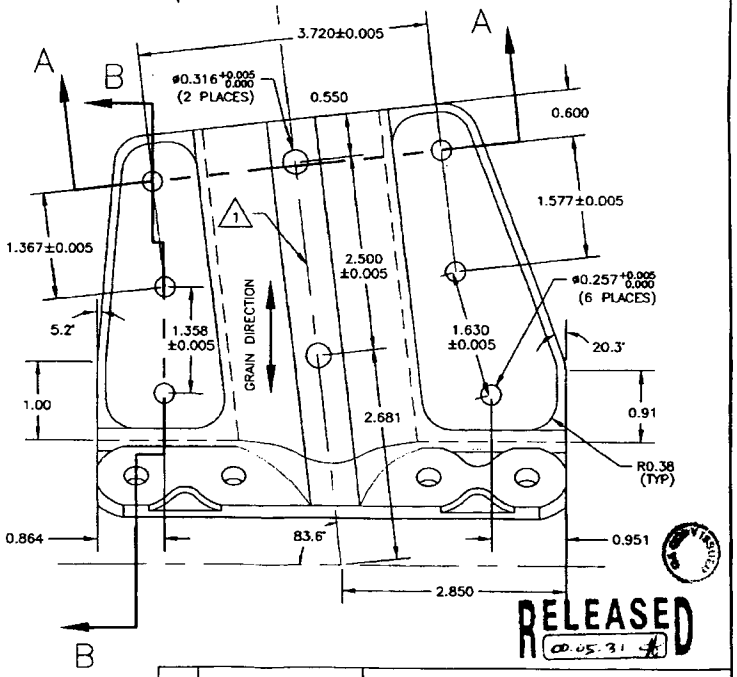


SECTION A–A

4/06/05

UNDER REVIEW





RELEASED

00.05.31

D2933–1 LH SADDLE (SHOWN)
D2933–2 RH SADDLE (OPPOSITE)

MATERIAL: 7075–T7351 (QQ–A–250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

1. ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
2. CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
3. CHAMFER 0.050" x 45°

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29790

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED	APPROVED	DRAWING NO. D2933	REV. B SHEET 1 OF 1
DATE 00.05.29		TITLE SADDLE INSIDE	SCALE 2:3

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 19, 2006 3:31 PM
To: 'S Shahbazian'
Cc: 'Provencal, Chris'; 'Charbonneau, Eric'
Subject: RE: Radius dimension on the saddle

Change the drawings. I guess we will also change the 0.313 crosstube hole dimensions as well.
See D2661 to D2668 as well as D2932 to D2933.

David

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: Thursday, October 19, 2006 1:16 PM
To: Shepherd, David
Cc: Provencal, Chris; Charbonneau, Eric
Subject: Radius dimension on the saddle

Dave,
On attach saddle drawing, according to Eric the marked-up radius that reads 0.30 and 0.25, should be 0.188 since the tooling has been changed long time ago, and apparently they have been machining those radiuses to 0.188 for a while. Do you see a problem with that? if not I will go ahead and change the drawing to reflect the changes.

Serge